

Work Order ID' 51275

August 13, 2009 10:55:21 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 8/13/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 09/02/13 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2580 | Rev D |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A *[Signature]*

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

[Signature]

4 9-8-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 5 or 10/15/09



6

BE 08/08/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

1 0 2E 09/08/18

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Run Start



Stop



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|---|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 150 QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | 27 | Sa/08/19 | | (10) | 5 | | |
| 160 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | 27 | Sa/08/19 | | (10) | 5 | | |
| 170 HandFinish Hand Finishing | Pressure Wash per QSI005 4.3 Memo | 0.00 0.00 | 27 | Jd 09/08/20 | | (11) | 0 | | |

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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|---|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 180 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo M112260 START TIME: 11:30pm OVEN TEMPERATURE: 320°F FINISH TIME: 12:00am | 0.00 | | | | 1 | 0 | | |
| 190 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 | | | | | | | |
| | | | | | | | | | |

BR 09-08-25

0

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 112391 ☐ ☐ ☐
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 112391 ☐ ☐ ☐
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 112106

BL 09-08-25

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Cust Item ID:

Required Date: 10/13/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) Soar/08/25



Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

PPF 50743 P 9/14/25

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/08/26

09-8-25

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 13, 2009 10:55:20 AM

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Work Order ID: 51275

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2580-1RevD | | Manufactured | No | | | 110 | Each | 8.0000 | 1.0000 | | | |
| 205 Skidtube bent detail | | | | | | | | | | | | |

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

6

50757

6

Main Warehouse

ST

2

50758

2

D2576-3RevG

Manufactured No

140

Each

147.0000

1.0000

Step (maching detail)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

147

43504

46

46661

101

D

11 9 - 8 - 17

B 50761

*

1

BE 09/08/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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August 13, 2009 10:55:20 AM

Work Order ID: 51275

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2579RevE | | Manufactured | No | | | 140 | Each | 92.0000 | 20.0000 | | | |
|  | | | | | | | | | | | | |
| Crossbolt Spacer | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | | |
|-------|----|--|
| ST | 92 | |
| 43988 | 4 | |
| 46434 | 4 | |
| 46956 | 2 | |
| 47797 | 28 | |
| 48272 | 54 | |

D2855RevA

Manufactured No

200

Each

37.0000

1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | | |
|---------|----|--|
| FP6 | 37 | |
| 50513 ✓ | 37 | |

20 *86 09/08/09*

1 BL 09-08-09

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Parent Item Name: Replacement Skidtube


Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

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|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| * AN3-5A  Bolt | | Purchased | No | | | 200 | Each | 2,540.000 | 2.0000 | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

M111707

ST

2540

100188

226

105057

2246

15205

68

AN960JD10L



Washer

Purchased

No

200

Each

6,733.000

2.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6733

101291

16

104885

153

105793

236

109632 ✓

1328

110985

5000

2 BL 09-08-25.

2 BL 09-08-25.

| W/O: | | WORK ORDER CHANGES | | | | | |
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Parent Item Name: Replacement Skidtube

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Start Date: 8/13/09

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Start Qty: 1.00

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|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| ALS7-1032-130 | | Purchased | No | | | 200 | Each | 3,628.000 | 50.0000 | | | |
| Insert | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

105855

108606

111529

111779

3628

16

52

1560

2000

200

Each

1,222.000

50.0000

AN3C4A

Purchased

No

BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112082

112314 ✓

1222

40

1182

50 BR 09-08-25

50 BR 09-08-25.

August 13, 2009 10:55:20 AM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube


Start Date: 8/13/09

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Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960C10L  washer | | Purchased | No | | | 200 | Each | 3,764.000 | 50.0000 | | | |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| OFFSHORE | | |
| FG | 100 | |
| 103585 | 100 | |
| Main Warehouse | | |
| ST | 3664 | |
| 112116 ✓ | 3664 | |

50 BR 09-08-25.

D3566-13RevC

Manufactured No



Gasket

200 Each 29.0000 1.0000



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 29 | |
| 45717 | 1 | |
| 46889 | 2 | |
| 48166 ✓ | 10 | |
| 50265 | 16 | |

1 BR 09-08-25.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 6

August 13, 2009 10:55:20 AM

Work Order ID: 51275

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D3566-5RevC

Manufactured

No

200

Each

4.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

51260

ST

4

36113

1

46186

1

47318

1

48167

1

D3566-1RevC

Manufactured

No

200

Each

13.0000

2.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

46349

1

47434

2

48557

3

51218

7

51259

1

BR 09-08-25.

2

BR 09-08-25.

August 13, 2009 10:55:20 AM

Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 7

August 13, 2009 10:55:20 AM

Work Order ID: 51275



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 8/13/09

Required Date: 10/13/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-11RevD | | Manufactured | No | | | 200 | Each | 15.0000 | 1.0000 | | | |
| | | | | | | | | | | | | |
| Wearshoe | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15

45823 1

48553 4

50112 ✓ 10

D3564-13RevD , Manufactured No



Wearshoe

200 Each 39.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP17 24

48554 ✓ 2

50270 ✓ 22

Main Warehouse

ST 15

45409 3

46495 10

47867 2

1 BL 09-08-25

1 BL 09-08-25.

August 13, 2009 10:55:20 AM

Shop Packet Print

Page 7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

August 13, 2009 10:55:20 AM

Work Order ID: 51275

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D3564-9RevD

Manufactured

No

200

Each

3.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

51258

ST

3

44659

1

45825

1

48556

1

1 BR 09-08-25

D3564-5RevD

Manufactured

No

200

Each

6.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

2

48555

2

Main Warehouse

ST

2

45824

1

47433

1

51257

1 BR 09-08-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 9

August 13, 2009 10:55:20 AM

Work Order ID: 51275



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 8/13/09

Required Date: 10/13/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2594-3RevC | | Manufactured | No | | | 200 | Each | 670.0000 | 16.0000 | | | |
| | | | | | | | | | | | | |
| O-Ring, 205 Skidtube | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 670

27168 44

29908 ✓ 626

D2594-1RevC

Manufactured No

200

Each

476.0000

16.0000



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 476

42221 16

42807 92

43884 3

46435 2

47251 ✓ 363

16 BR 09-08-25.

16 BR 09-08-25

August 13, 2009 10:55:20 AM

Shop Packet Print

Page 9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART**RELEASED**
07-06-28 #

| | | | |
|------------------|----------------|--|------------------------|
| DESIGN # | DRAWN BY RH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2580 | REV. D SHEET 1 OF 3 |
| DATE 07.02.27 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |
| D | 07.02.27 | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 | |

| QTY -041 | QTY -045 | Part Number | Description |
|-------------|-------------|---|-------------------|
| X | | D2580-041 | SKIDTUBE ASSEMBLY |
| | X | D2580-045 | SKIDTUBE ASSEMBLY |
| | | | |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 1 | 1 | D2576-3 | STEP |
| 20 | 24 | D2579 | CROSS BOLT SPACER |
| 16 | 16 | D2594-1 | PLUG |
| 16 | 16 | D2594-3 | O-RING |
| 1 | 1 | D2596 | 205 WEB |
| 1 | 1 | D2855 | AFT CAP |
| 1 | 1 | D3564-5 | WEARSHOE |
| 1 | 1 | D3564-9 | WEARSHOE |
| 1 | 1 | D3564-11 | WEARSHOE |
| 1 | 1 | D3564-13 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | 1 | D3566-13 | GASKET |
| | | | |
| 50 | 50 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130 | INSERT |
| 50 | 50 | AN3C4A | BOLT |
| 2 | 2 | AN3-5A | BOLT |
| 50 | 50 | AN960C10L | WASHER |
| 2 | 2 | AN960JD10L | WASHER |

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WORK ORDER
NO. 51275

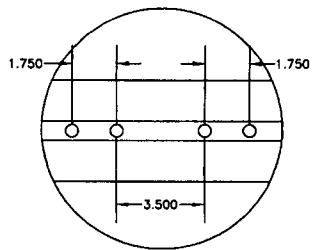
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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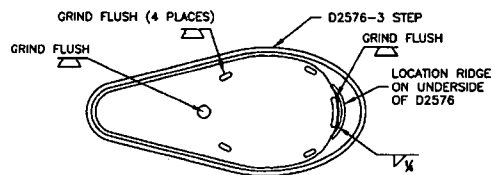
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DETAIL A
SCALE 5:24

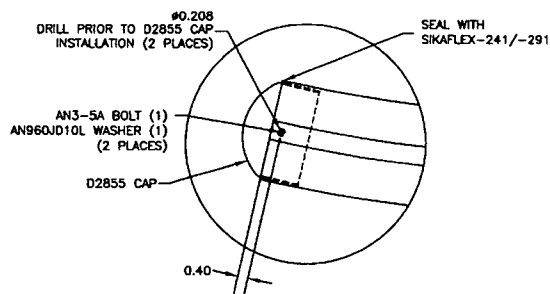


RELEASED
07 de 28

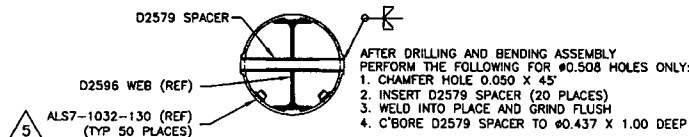
DETAIL B
SCALE 5:24



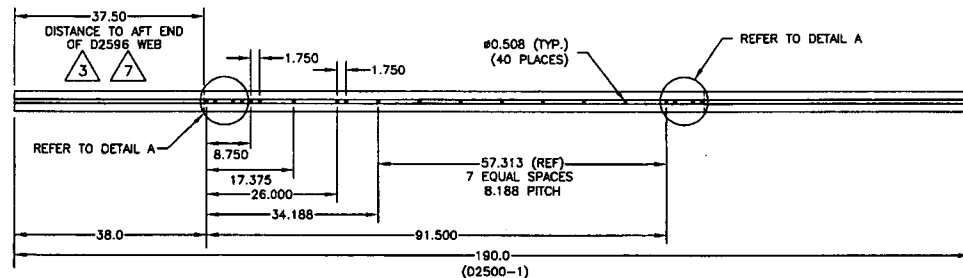
DETAIL C
SCALE 5:24



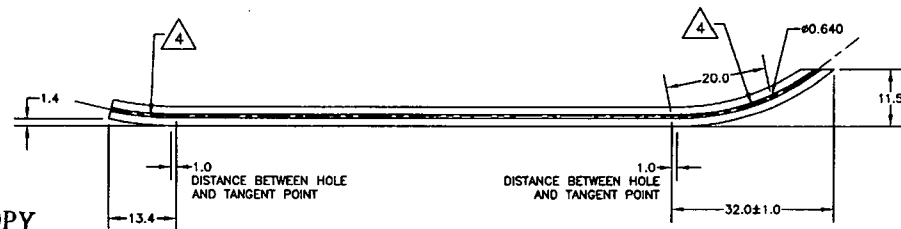
SECTION D-D
SCALE 5:24



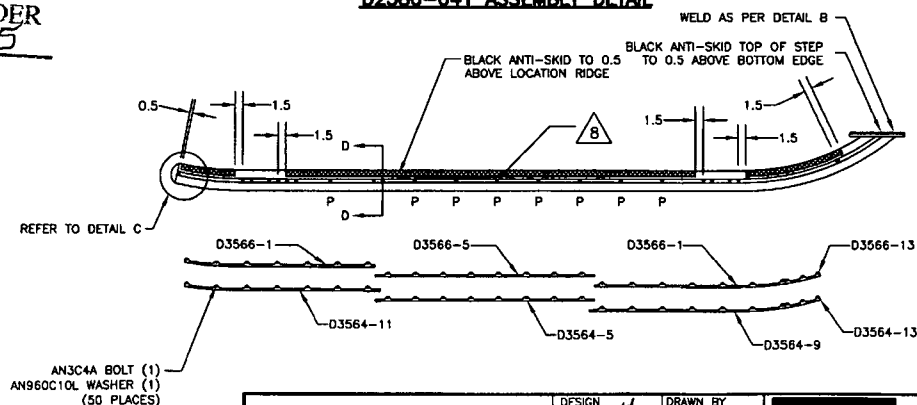
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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| | | | |
|---------|----------|-----------------------|---------------------|
| DESIGN | DRAWN BY | DART | DART AEROSPACE LTD. |
| CHECKED | APPROVED | DRAWING NO. | REV. 0 |
| DATE | 07.02.27 | D2580 | SHEET 2 OF 3 |
| | | TITLE | SCALE |
| | | 205 SKIDTUBE ASSEMBLY | 1:24 |

RELEASED
07-16-28

Diagram illustrating the underside of the D2576 component, showing the locations for grinding and the location ridge.

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- 1/4

[illegible]

NOTE ii)

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D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP. 50 PLACES)

5

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

Ø0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

91.500

38.0

190.0
(D2500-1)

Technical drawing of a propeller shaft. The shaft is shown in profile, with a curved upper section and a straight lower section. Dimensions are given in inches. Callouts include: 5.985, 1.4, 5.338 (REF), 51.340, 39.580, 5.915, 3.630 (REF), #0.508 (8 PLACES), 20.0, #0.640, 11, 1.0, 13.4, 1.0, 32.0 ± 1.0, and 4. The drawing is labeled (MAKE FROM D2580-1 DRILLING DETAIL).

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

REFER TO DETAIL G

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN56OC10L WASHER (1)

(50 PLACES)

| | |
|--------|----------|
| DESIGN | DRAWN BY |
|--------|----------|

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| | |
|----------|-------------|
| DRAWN BY | RH |
| APPROVED | [Signature] |

| | | | |
|---------------------------------|--|---|--|
| DART | | DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA | |
| DRAWING NO. D2580 | | REV. SHEET 3 OF 3 | |
| TITLE 205 SKIDTIURE ASSEMBLY | | SCALE | |

NO. 206

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 50844
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[] fail[]
pass[] fail[]
pass[☒] fail[]
pass[] fail[]
pass[] fail[]
pass[] fail[]

Qualifier P. D. W.

Date of Test Coupon 09.08.13

Welder Barday Elliott

Date of Test Coupon 09.08.13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld